

Date: Friday, 01/08/2008 3:31:19 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FRONT LEG FITTING ASS'Y
Job Number : 40949	
Estimate Number : 13342	
P.O. Number :	Part Number : D3762041
This Issue : 01/08/2008 S.O. No. :	Drawing Number : D3762 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 40948	Material :
Written By :	Due Date : 21/08/2008 Qty: 6 Um: Each
Checked & Approved By : <u>JLD 08.8.05</u>	
Comment : Est Rev:A 08-05-20 new issue DD verified by:ec Est Rev:B 08-06-17 rev.A as per dwg DD verified:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D37621	Fitting
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)
 Fitting
 batch: B 41007 ✓ SP 08.08.13 (2x)

3.0	D37623	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Tube
 batch: B 40480 ✓ SP 08.08.13 (2x)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 1-assemble as per dwg D3762 using locating pins DT9014 and tack weld parts in place SP 08.08.13
DT9039
 2- take pins out before welding SP 08.08.13
 3-weld as per dwg D3762 per QSI004
 Alum. rod Batch: M 108037 SP 08.08.14 (6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:31:19 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT LEG FITTING ASS'Y

Job Number: 40949

Part Number: D3762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



(X6)

Comment: VISUAL WELDING INSPECTION

08/08/14
08/08/14

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/14 (6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08/08/14

(6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-14

(X6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF 08-08-14

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(6)
08/08/15

Job Completion



MF 08-08-14

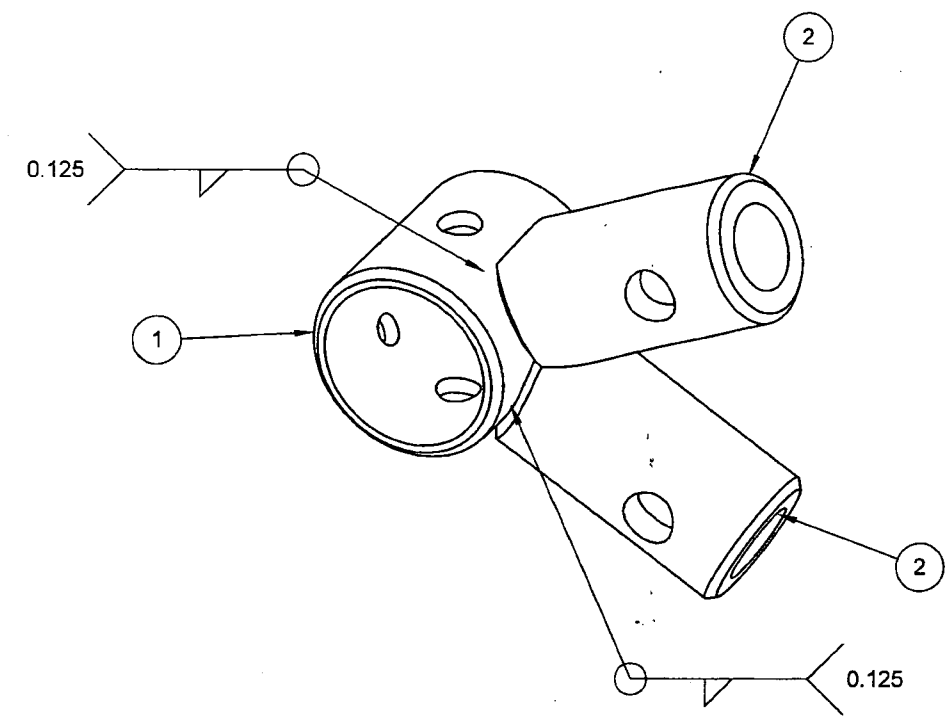
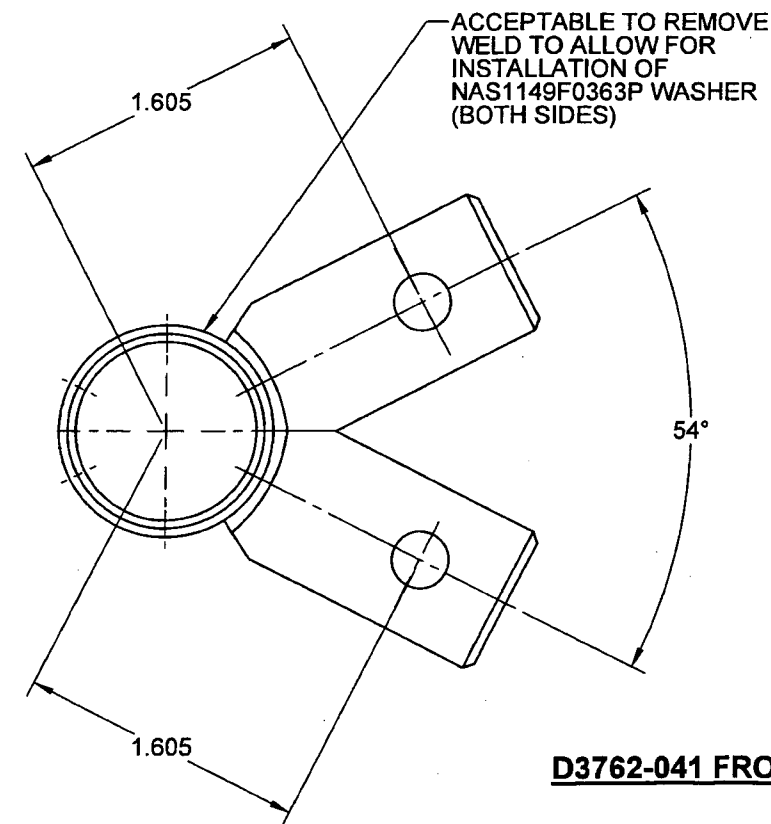
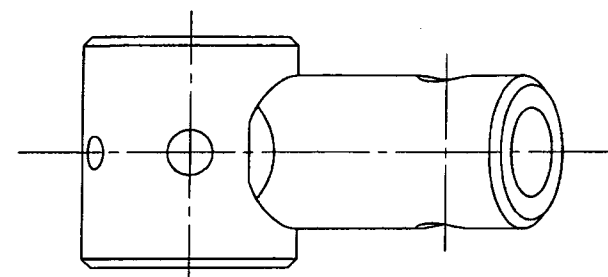
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3762-3	TUBE	1
2	D3762-1	FITTING	2

D3762-041 FRONT LEG FITTING ASSY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs
 - 8) WELD: PER DART QSI 004

RELEASED
08-08-16

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NO. 40949

A		NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION			BY	CDATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 3	
DRAWN	HS				
CHECKED	PA	DRAWING NO. D3762		SCALE NTS	
MFG. APPR.	[Signature]	TITLE FRONT LEG FITTING			
APPROVED	[Signature]				
DE APPR.	[Signature]				
DATE	08.06.04			<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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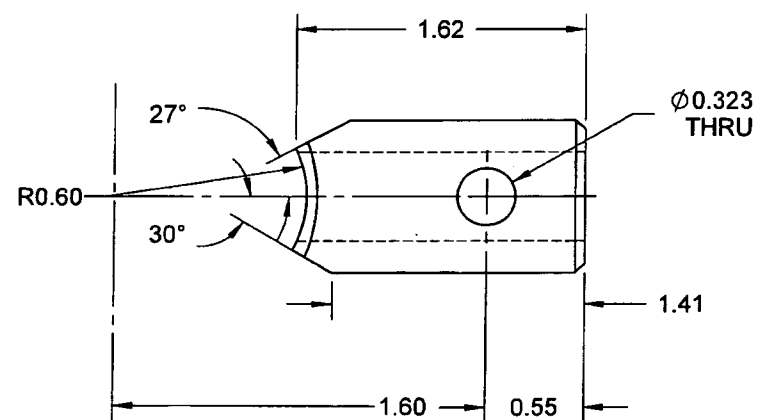
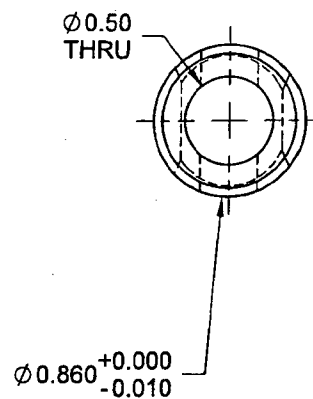
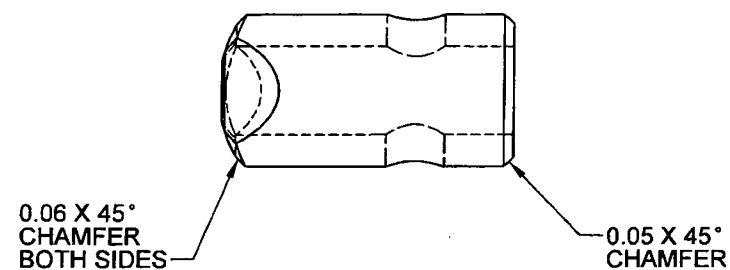
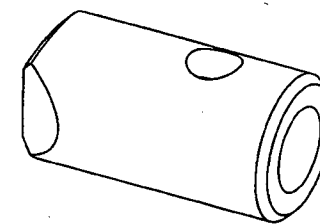
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D3762-1 FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC. M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

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08.06.16

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MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
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DATE	08.06.04		

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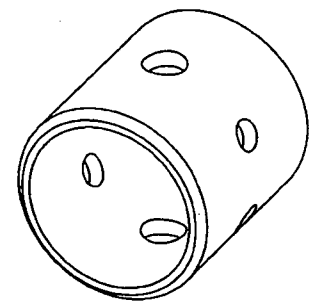
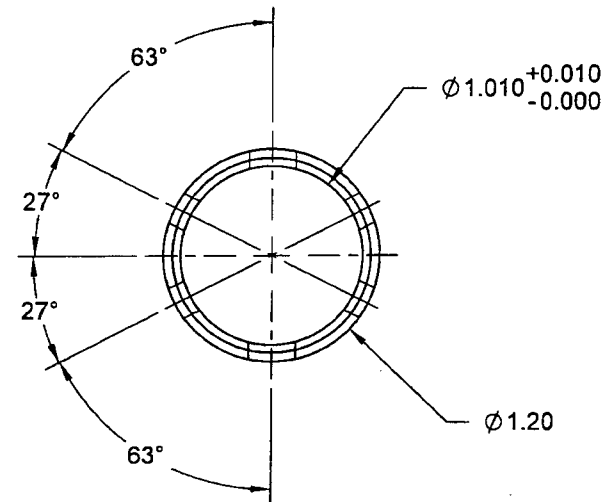
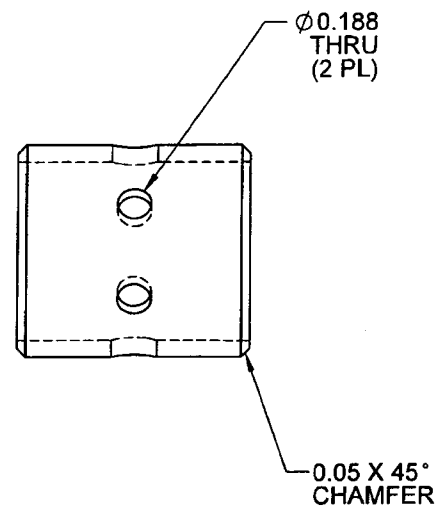
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D3762-3 TUBE

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WORK ORDER
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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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CHECKED	HS	DRAWING NO. D3762	REV. A
MFG. APPR.	HS		SHEET 3 OF 3
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